



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9710

Job Sheet 208748



Part No: 646.9710

Job Qty: 30 pcs

Part Name: Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/31/20

Job Tracking No:

Due Date: 4/30/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.9700 REV.H IPP REV:A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	HAAS 4 Axis	30 pcs		4/16/20	0.22	15.00	HAAS - 1	W5000 - 1	ALA / J.C.C.
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 2	30 pcs		4/16/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32	J.C.C. 20-04-15	
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

20/04/13



Container No: S270828



Part: 646.9710

Job No: 208748

Serial No/Batch: S270828

Revision: Rev H

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/15/20

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					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
130	QC 8	30 pcs	4/16/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	mm 20/4/19
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
140	Outsource - 4 - Anodize	30 pcs	4/30/20		ATG001-VC	10
						2020-04-20
150	Packaging 2-1 - Receive - B4B	30 pcs	4/30/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	110 MAY 21 2020
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	

				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
155 QC 6	30 pcs	4/30/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS
				QC 6 - 40	81
				QC 6 - 81	9-89
				QC 6 - 82	
180 Packaging 3-1 - Stock - B4B	30 pcs	4/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Plex 3/31/20 2:53 PM Dart.lajeunesse.marie	

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				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	30	4/30/20	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 110 - (HAAS CNC Vertical Machine), 1-Machine per folio FB130 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Outsource process-Anodize per QSI017 4.1.10.1), Issue P/O to: <u>4635</u> Hard Black Anodize Color Black and Prime as per Dwg 646.9700 150 - (Receive & Inspect for Damage & Mat'l Certs) 155 - (QC6- All purchased or subcontracted products) 180 - (Identify as per dwg & Stock Location: _____), ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** 190 - (QC21- Final Inspection - Work Order Release)					JUN 09 2020 28 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	18.6300 ft (.621 ea)	110-HAAS 4 Axis	S217216 XIX S223519 XII

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-HAAS 4 Axis	M7075T6S1.000X5.000	19	37	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body	0.130Inches $\pm$ 0.010	0.140 0.120	.130	
2	Body	45.0Angle $\pm$ 0.5	45.5 44.5	45°	
3	Body	1.500Inches $\pm$ 0.005	1.505 1.495	1.501	
4	Body	0.352Inches $\pm$ 0.005 + 0.005 - 0.000	0.357 0.352	.354	
5	Body	0.100Inches $\pm$ 0.010	0.110 0.090	.098	
6	Body	45.0Angle $\pm$ 0.5	45.5 44.5	45°	
7	Body	0.875Inches $\pm$ 0.005	0.880 0.870	.879	
8	Body	0.700Inches $\pm$ 0.005	0.705 0.695	.701	
9	Body	5.500Inches $\pm$ 0.005	5.505 5.495	5.500	
10	Body	0.660Inches $\pm$ 0.005	0.665 0.655	.660	
11	Body	0.660Inches $\pm$ 0.005	0.665 0.655	.660	
12	Body	0.278Inches $\pm$ 0.002	0.280 0.276	.279	
13	Body	0.339Inches $\pm$ 0.002	0.341 0.337	.339	
14	Body	0.352Inches $\pm$ 0.002	0.354 0.350	.352	
15	Body	0.372Inches $\pm$ 0.002	0.374 0.370	.372	
16	Body	1.067Inches $\pm$ 0.002	1.069 1.065	1.068	
17	Body	2.608Inches $\pm$ 0.002	2.610 2.606	2.608	
18	Body	2.750Inches $\pm$ 0.002	2.752 2.748	2.751	
19	Body	2.892Inches $\pm$ 0.002	2.894 2.890	2.893	
20	Body	3.348Inches $\pm$ 0.002	3.350 3.346	3.347	
21	Body	3.597Inches $\pm$ 0.002	3.599 3.595	3.596	
22	Body	3.847Inches $\pm$ 0.002	3.849 3.845	3.846	
23	Body	0.351Inches $\pm$ 0.002	0.353 0.349	.351	
24	Body	0.544Inches $\pm$ 0.002	0.546 0.542	.544	
25	Body	2.195Inches $\pm$ 0.002	2.197 2.193	2.195	
26	Body	2.304Inches $\pm$ 0.002	2.306	2.305	

			2.302	
27	Body	2.451Inches ± 0.002	2.453 2.449	2.451
28	Body	2.639Inches ± 0.002	2.641 2.637	2.639
29	Body	3.395Inches ± 0.002	3.397 3.393	3.395
30	Body	3.495Inches ± 0.002	3.497 3.493	3.495
31	Body	4.551Inches ± 0.002	4.553 4.549	4.551
32	Body	4.595Inches ± 0.002	4.597 4.593	4.595
33	Body	4.687Inches ± 0.002	4.689 4.685	4.687
34	Body	4.734Inches ± 0.002	4.736 4.732	4.735
35	Body	6.651Inches ± 0.002	6.653 6.649	6.652
36	Body	0.201Inches + 0.005 - 0.001	0.206 0.200	.201
37	Body	0.177Inches + 0.005 - 0.001	0.182 0.176	.177
38	Body	7.026Inches ± 0.005	7.031 7.021	7.027
39	Body	4.245Inches ± 0.005	4.250 4.240	4.245

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046305



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046305

PO Date: 4/20/20

Due Date: 5/6/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	205002	647.1812	647.1800 REV.A	Shim : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Partial	-	5/6/20	196 pcs	186 pcs	10 pcs	\$7.14/pcs	\$71.40
11	204890	D5532-041	D5532 Rev A	Valve Cap Assembly : Various STC's Issue P/O: Blue Anodize as per Dwg D5532 BLUE ANODIZE PER MIL-A- 8625F TYPE I or IB or IC or II or IIB CLASS 2	Firmed	-	5/6/20	10 pcs	0 pcs	10 pcs	\$8.62/pcs	\$86.20
25	208748	646.9710	646.9700 Rev H	Body : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1), Issue P/O to: Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed	-	5/6/20	30 pcs	0 pcs	30 pcs	\$14.79/pcs	\$442.70
Grand Total:												\$601.30

Grand Total: \$601.30

KGuerin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046305



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

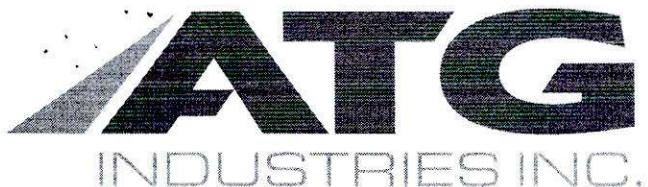
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/20/20 12:39 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920163

Date: 20-May-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
30 ea	Part: 646.9710 Body Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5265778 Job: 27528 PO: POHB046305	Rev: H Expiry Date: 8/21 Line: 25	D E 9- DAS 81 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: MAY 20 2020 Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

RECEIVED
MAY 20 2020
DART AEROSPACE LTD.